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THE UNITED STATES OF AMERICA

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February 08, 2005

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APPLICATION NUMBER: 60/536,838

FILING DATE: January 16, 2004

RELATED PCT APPLICATION NUMBER: PCT/US05/01200



Certified by

Don W. Duckas

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011604

16711 U.S. PTO

PTO/SB/16 (01-04)

Approved for use through 07/31/2006. OMB 0651-0032

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PROVISIONAL APPLICATION FOR PATENT COVER SHEET

This is a request for filing a PROVISIONAL APPLICATION FOR PATENT under 37 CFR 1.53(c).

Express Mail Label No.

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60/536838

011604

INVENTOR(S)					
Given Name (first and middle (if any))		Family Name or Surname		Residence (City and either State or Foreign Country)	
William M.		HEYN		Norwalk CT 06854	
Additional inventors are being named on the _____ separately numbered sheets attached hereto					
TITLE OF THE INVENTION (500 characters max)					
ANGLED SEALING SURFACE AND METHOD OF MANUFACTURE					
Direct all correspondence to: CORRESPONDENCE ADDRESS					
<input checked="" type="checkbox"/> Customer Number:		25628			
OR					
<input type="checkbox"/> Firm or Individual Name					
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ENCLOSED APPLICATION PARTS (check all that apply)					
<input checked="" type="checkbox"/> Specification Number of Pages		3		<input type="checkbox"/> CD(s), Number _____	
<input type="checkbox"/> Drawing(s) Number of Sheets				<input type="checkbox"/> Other (specify) _____	
<input type="checkbox"/> Application Data Sheet. See 37 CFR 1.76					
METHOD OF PAYMENT OF FILING FEES FOR THIS PROVISIONAL APPLICATION FOR PATENT					
<input checked="" type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27.				FILING FEE Amount (\$) \$80.00	
<input checked="" type="checkbox"/> A check or money order is enclosed to cover the filing fees.					
<input checked="" type="checkbox"/> The Director is hereby authorized to charge filing fees or credit any overpayment to Deposit Account Number: 082670					
<input type="checkbox"/> Payment by credit card. Form PTO-2038 is attached.					
The invention was made by an agency of the United States Government or under a contract with an agency of the United States Government.					
<input checked="" type="checkbox"/> No.					
<input type="checkbox"/> Yes, the name of the U.S. Government agency and the Government contract number are: _____					

[Page 1 of 2]

Respectfully submitted,

SIGNATURE

William H. Holt

TYPED or PRINTED NAME William H. Holt

TELEPHONE 703 838 2700

Date January 16, 2004

REGISTRATION NO. 20,766

(if appropriate)

Docket Number: Heyn - P1

USE ONLY FOR FILING A PROVISIONAL APPLICATION FOR PATENT

This collection of information is required by 37 CFR 1.51. The information is required to obtain or retain a benefit by the public which is to file (and by the USPTO to process) an application. Confidentiality is governed by 35 U.S.C. 122 and 37 CFR 1.14. This collection is estimated to take 8 hours to complete, including gathering, preparing, and submitting the completed application form to the USPTO. Time will vary depending upon the individual case. Any comments on the amount of time you require to complete this form and/or suggestions for reducing this burden, should be sent to the Chief Information Officer, U.S. Patent and Trademark Office, U.S. Department of Commerce, P.O. Box 1450, Alexandria, VA 22313-1450. DO NOT SEND FEES OR COMPLETED FORMS TO THIS ADDRESS. SEND TO: Mail Stop Provisional Application, Commissioner for Patents, P.O. Box 1450, Alexandria, VA 22313-1450.

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Additional Page

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Docket Number

INVENTOR(S)/APPLICANT(S)

Given Name (first and middle (if any))	Family or Surname	Residence (City and either State or Foreign Country)

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Number _____ of _____

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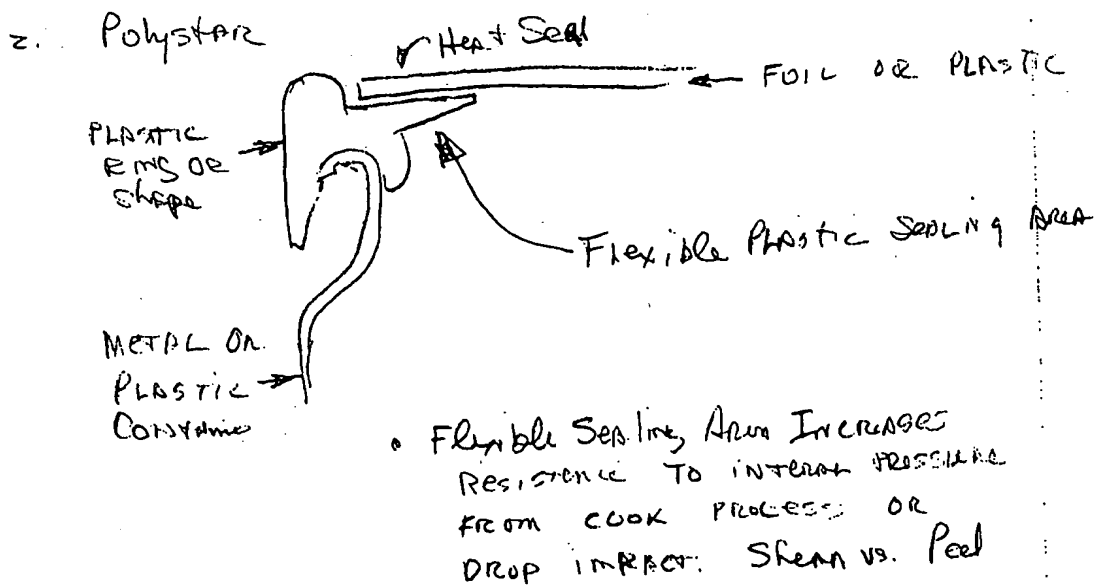
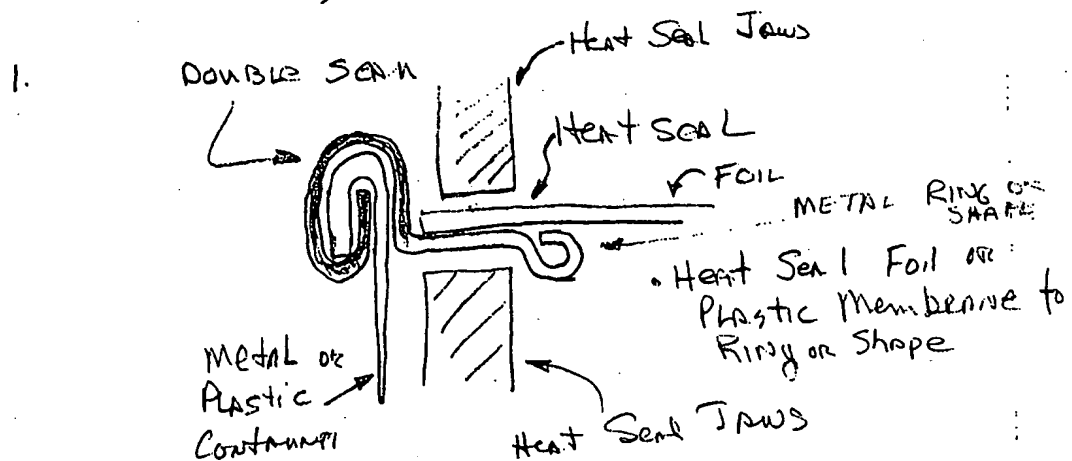
TITLE: ANGLED SEALING SURFACE NEW METHOD OF MANUFACTURE

William M. Hearn

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Current Technology:



Invention Aetial:

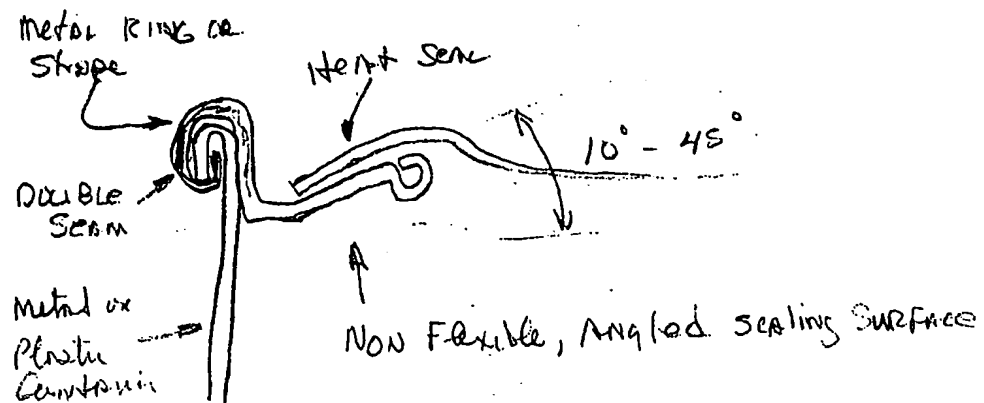
3. IF METAL RING OR SHAPE IS A REQUIREMENT, A NON HORIZONTAL SEALING SURFACE WOULD INCREASE RESISTANCE TO INTERNAL PRESSURE.

Therefore, FORMING A ANGLED SEALING SURFACE, IN METAL WHICH IS NOT FLEXIBLE, WOULD INCREASE BUILT UP

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ARTICAL

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TEST RESULTS: FLAT SEAL SURFACE VS ANGLED 25°

Test #	Descrip	Burst (PSI)
1	FLAT	22
2	"	25
3	"	22
4	"	22
5	"	24
6	"	22
7	"	25
	Ave	22.8
8	ANGLED	47
9	"	41
10	"	45
11	"	47
12	"	47
13	"	48
14	"	45
	Ave	45.7

25° ANGLED YIELDED 100% INCREASE IN BURST PSI

Invention Method:

IF HEAT SEAL WAS ATTEMPTED ON ANGLED SEALING AREA, FOIL WOULD WRINKLE CAUSING POTENTIAL LEAKS OR REDUCED STRENGTH.

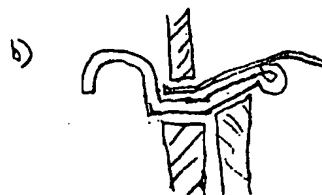
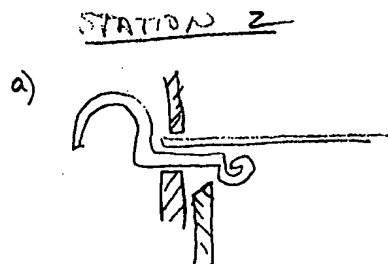
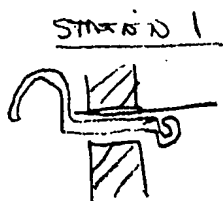
THEFORE

- 1.) Heat Seal must be accomplished in the FLAT AND REFORMED
- 2.) THE FOIL MUST BE CLAMPED COINCIDENTALLY OR PRIOR TO REFORMING TO AVOID REFORMING THE SEAL

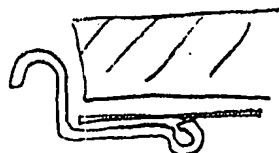
THIS CAN BE ACCOMPLISHED IN PROGRESSIVE STATIONS ON THE LID MANUFACTURING LINE.

STATION 1 HEAT SEAL

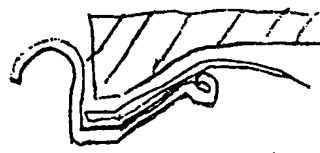
STATION 2 CLAMP FOIL AND REFORM



Seaming Chuck:



NORMAL CHUCK



RELIEVED CHUCK

CHUCK MUST BE RELIEVED 360° TO AVOID CRUSHING THE REFORMED SECTION